

Date: Wednesday, 3/8/2006 12:02:03 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FOLDING STEP WELDMENT LH
Job Number	: 26157		
Estimate Number	: 10697		
P.O. Number	: <i>N/A</i>	Part Number	: D3388042
This Issue	: 3/8/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D3388 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 25927	Material	: <i>N/A</i>
Written By	: <i>See comment below</i>	Due Date	: 4/10/2006 Qty: 4 Um: Each
Checked & Approved By	: <i>06.03.08</i>		
Comment	: Est. B 05.06.10 Added Step 11 KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 D2622-120C extrusion  
 Batch: *324563*

*PE 06.04.29*

4

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1  
 CUT D2622-120C extrusion 85.15" long as per Dwg D3388

*PE 06.04.29*

4

Deburr and bevel ends for welding

*PE 06.05.1*

4

3.0	D2734	206 Step Endplate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)  
 206 Step Endplate  
 Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	<i>324402</i>

*PE 06.05.1*

4.0	D33872	Arm
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)  
 Arm  
 Pick:

Qty	Part Number	Description	Batch
2	D3387-2	Arm	<i>326631</i>

*PE 06.05.1*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 12:02:03 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FOLDING STEP WELDMENT LH

RH

Job Number: 26157

Part Number: D3388042

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld arms and end caps as per Dwg D3388.

Inspect for foreign objects as per QSI 024.

Grind end cap welds flush

Dwg Rev: A

P.E. 06.05.01

FF 06.05.04

P10

4

4

6.0 QC5/9 WELD INSPECTION



Comment: WELD INSPECTION

see P10  
06/05/04

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Wing Walk as per Dwg D3388 and QSI 005 4.4

powder coat (see P10 7.1)  
06 06 06 CD

H.M 06/05/09

4

8.0 D2808 Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Spacer

Pick:

Qty Part Number Description Batch

2 x D2808 Spacer

1126648

Press spacer into D3387-2 arm as per Dwg D3387

SAD 06/06/08

4

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/06/08

4

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location GA

SAD 06/06/08

4

11.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/14

W De. Dolly

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06-05-08	5.1	Inspect QCS 9	DA	06-05-08	4	UL	2	
	6.1	Inspect Machine QC3	2	06-05-10	4			
	6.2	weld 2nd end cap and grind flush as per eng. spec. / PF 06.05.11	12	06-05-10	4			
	6.3	Inspect QCS 9	1D	06-05-15 06-05-12	4	A-05-08	A-05-08	
	6.4	Align end cap as per QSI 005	H.M	06-05-19	4			
	7.1	Powder 6021 friction change	DL	06-05-09	4			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Job Completion



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

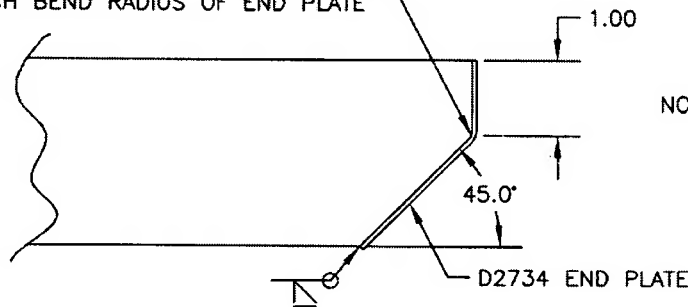
**DART**

RELEASED

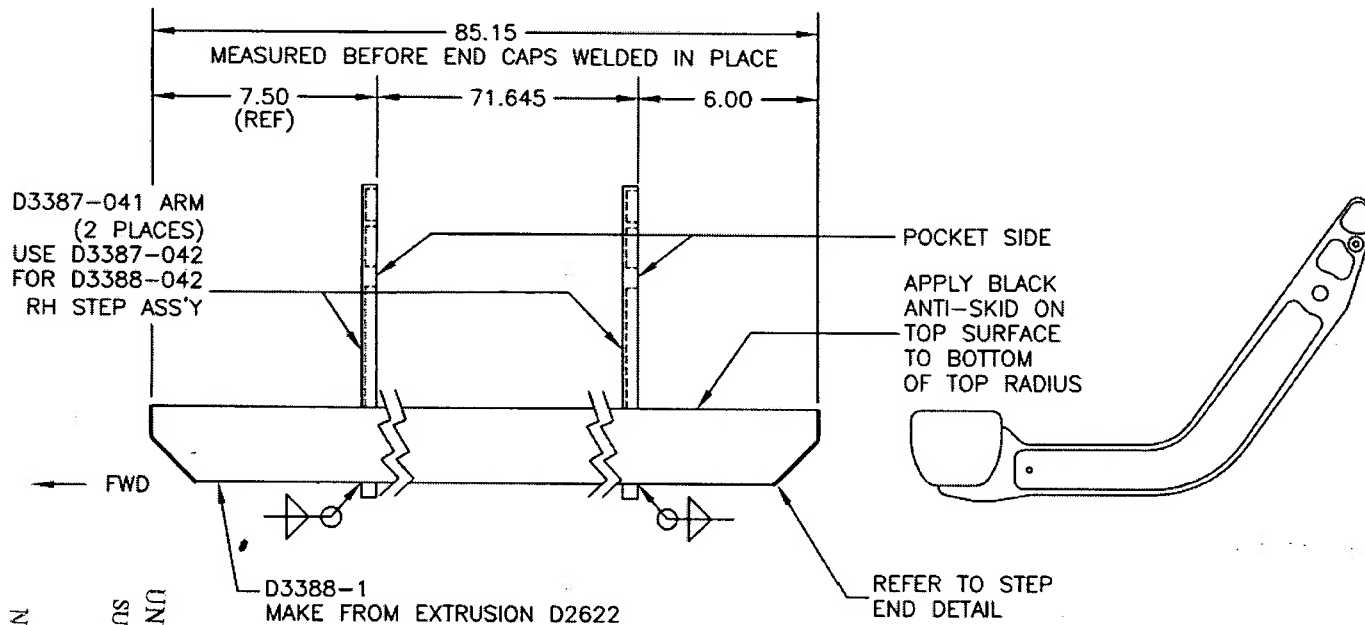
05-03-1

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL  
NOT TO SCALE



**D3388-041 LH STEP ASSEMBLY (SHOWN)**  
**D3388-042 RH STEP ASSEMBLY (OPPOSITE)**

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
WELD PER DART QSI 004 UNLESS OTHERWISE NOTED

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)

OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. A
CP	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
CP	CP	D3388	
DATE	TITLE	SCALE	
05.01.20	STEP WELDMENT	NTS	
A	05.01.20	NEW ISSUE	

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
ENGINEERING  
WORK ORDER  
NO. 36157